

504

Work Order ID 63006

October 15, 2010 2:37:34 PM



Item ID:	D3183-045	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bearing Assembly					
Start Date:	10/15/10	Start Qty:	30.00		Cust Item ID:	
Required Date:	10/20/10	Req'd Qty:	30.00		Customer:	

Reference:

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3183	Rev C1								

100		0.00							
	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn D3183-9 Cap as per Folio FA388 Deburr								

J.F.S. 10/10/25

31 0

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

J.F.S. 10/10/25

31 0

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

J.A 10/10/25

31 0

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Item ID: D3183-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 10/15/10 Start Qty: 30.00



Cust Item ID:

Required Date: 10/20/10 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Packaging	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							

4510/10/27 (31)

counted
(x31)

60/10/27 (31)

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Item ID: D3183-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 10/15/10 Start Qty: 30.00



Cust Item ID:

Required Date: 10/20/10 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

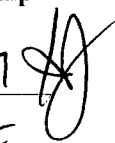


QC

Memo

0.00

Quality Control

10/10/27 
mf
10-10-27

Picklist Print

October 15, 2010 2:37:32 PM

Page 1

Work Order ID: 63006

Parent Item: D3183-045

Parent Item Name: Bearing Assembly

Start Date: 10/15/10

Required Date: 10/20/10

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A 04.02.18 New issue KJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3183-5		Manufactured	No			110	Each	3.0000	1	30			
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Bearing

Location

Loc Qty

Loc Code

ST236

3

47606

1

52135

2

MDELNR1.000

Purchased

No

130

f

12.6300

0.0333

1.051579



Delrin Round Bar 1"

Location

Loc Qty

Loc Code

MAT

7.34

114733

7.34

MAT050

5.29

108804

5.29



10/10/27
B63007 (31x)



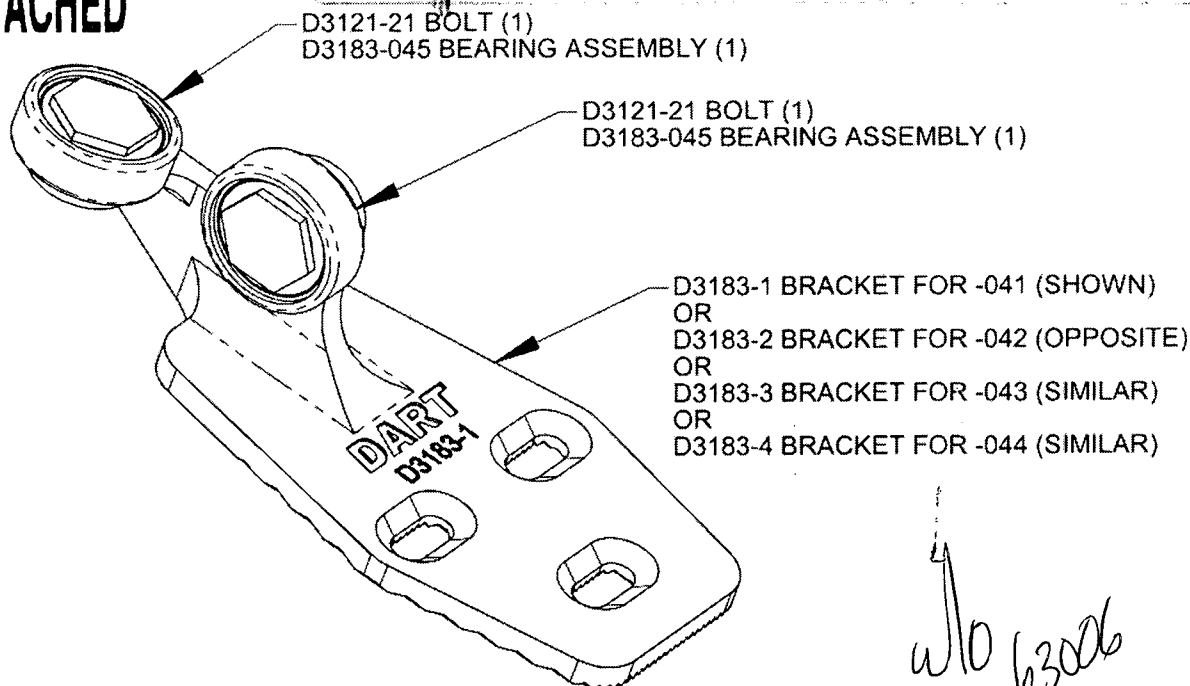
J.F.S. 10/10/25

31 1.0865

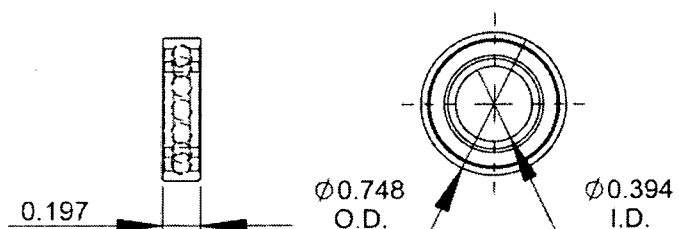


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	#	04.11.07 10.830 WAS 0.850 L	

RELEASED
04.03.01
DEO ATTACHED

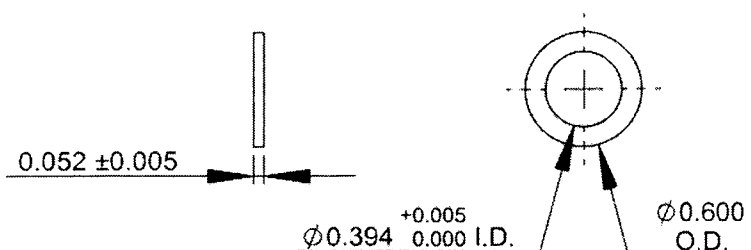


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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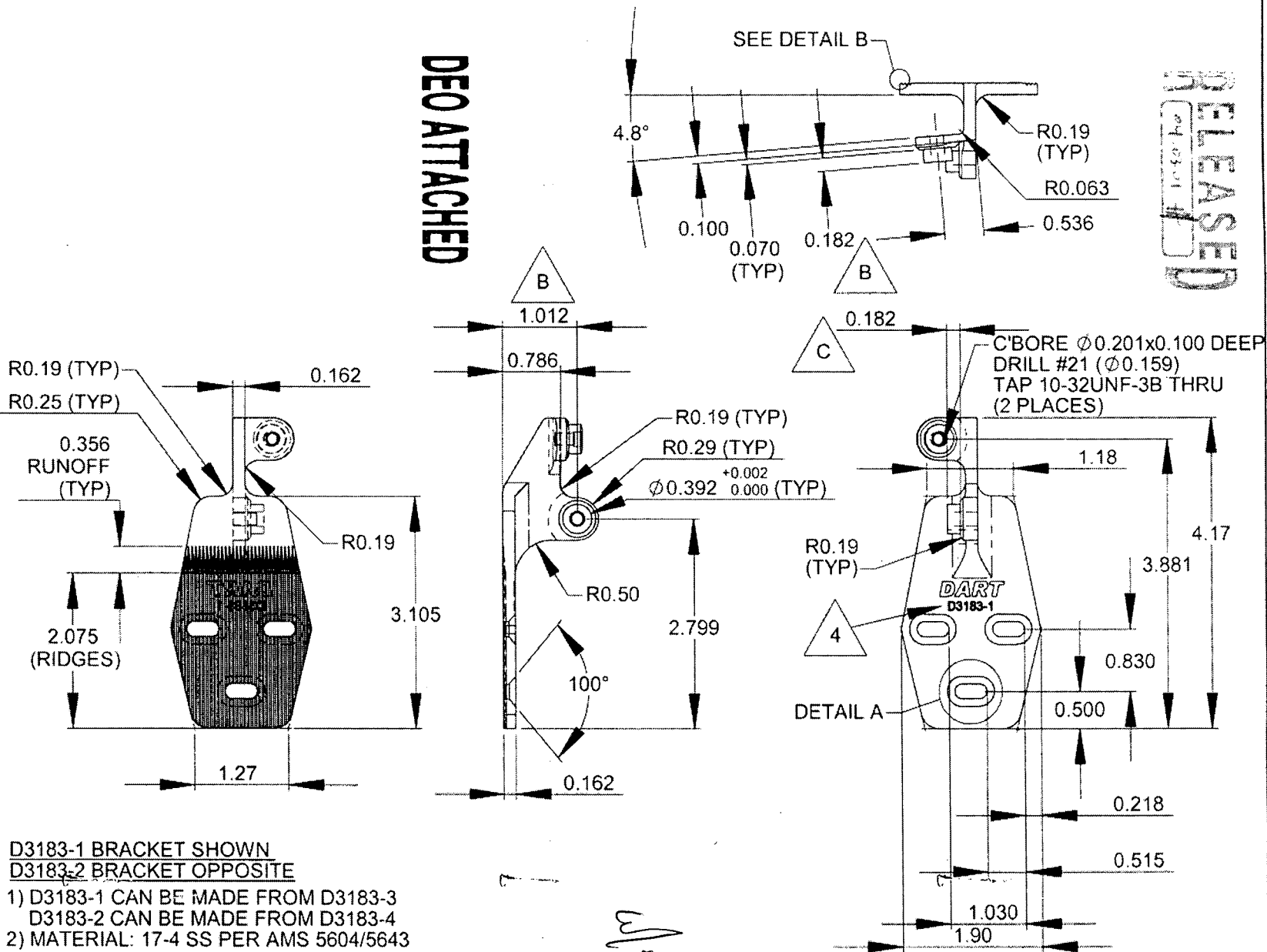
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		REV. C
04.02.17		SHEET 2 OF 4
	TITLE	SCALE
	BRACKET ASSEMBLY	1:2

RELEASED

DEO ATTACHED



**D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE**

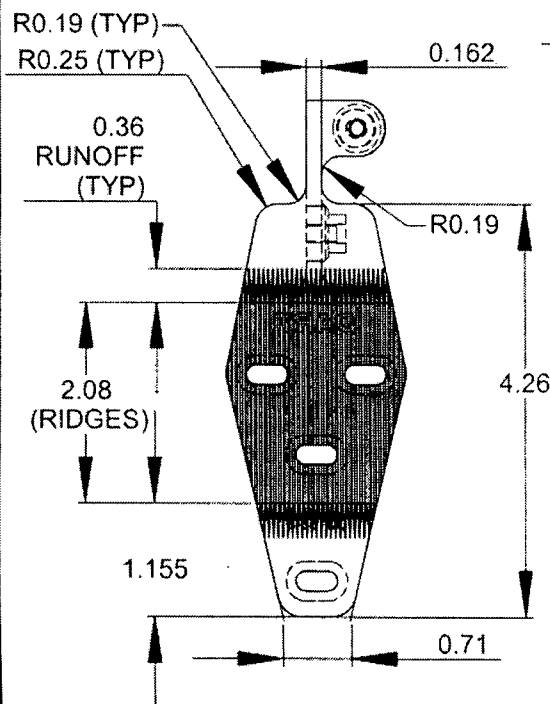
- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

W/b 63006

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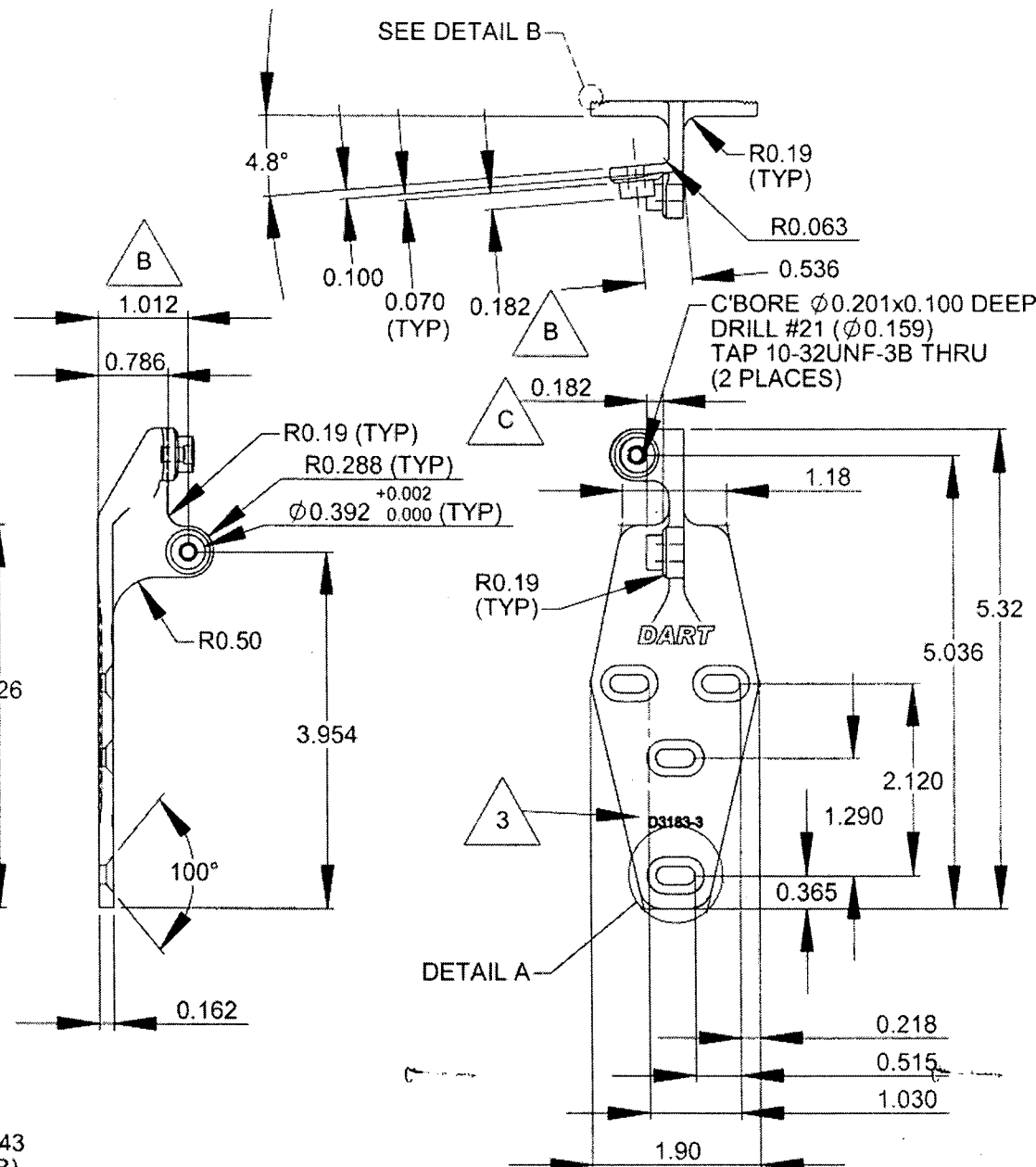
DEO ATTACHED

RELEASED



D3183-3 BRACKET SHOWN
 (REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
 (REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE STRENGTH = 150 ksi
 MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



w/063006

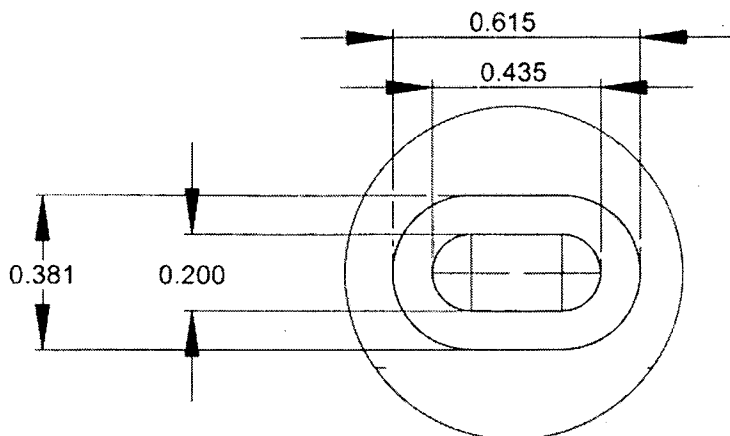
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	04.02.17	DRAWING NO. D3183
TITLE	BRACKET ASSEMBLY	REV. C
SCALE	1:2	SHEET 3 OF 4



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

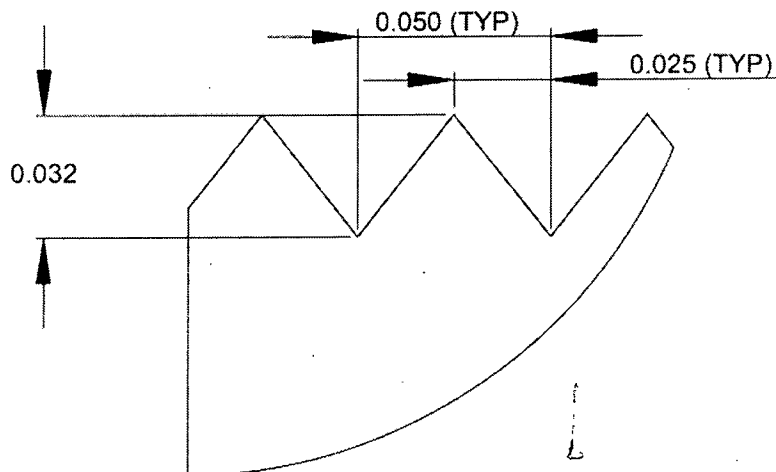


DETAIL A (2 : 1)

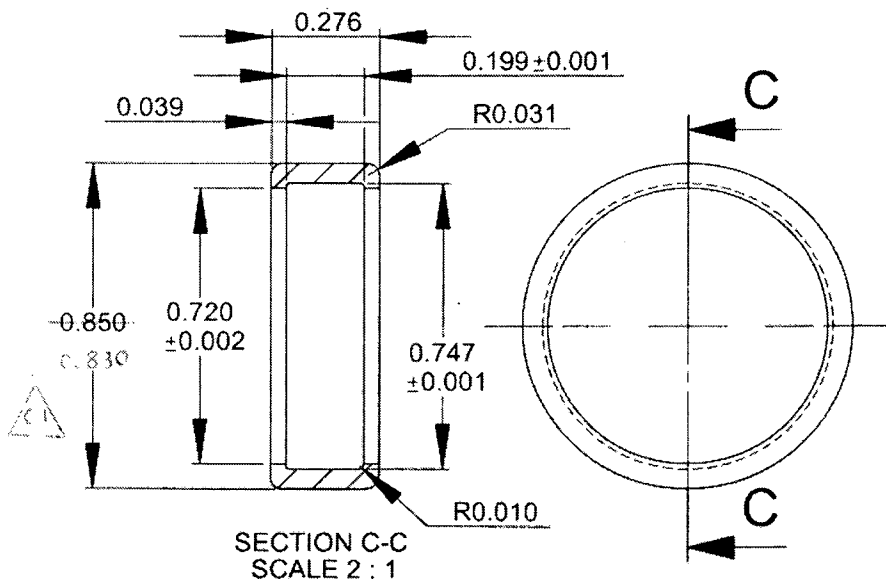
who 6300

RELEASED
04 03 01

DEO ATTACHED



DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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